

Work Order ID 68369

Tuesday, April 12, 2011 10:14:39 AM



Page 1

Item ID: D3637-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Handwritten initials

Date: 11-04-12 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3637	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3637 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

2024.050

B11-4-21

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-21

Pto

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

8/14/20

(410)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3637-3 PAR #: N/A Fault Category: Prod. Eng. Coord NCR: Yes No DQA: 1 Date: 11.05.05
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CK Date: 11/05/06

NCR: <u>68369</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/04/05</u>	<u>100</u>	<u>Found Qty x4 Parts measure</u> <u>0.100" too short in length.</u> <u>(4.97" should be. measure 4.87" (corr))</u> <u>R.L. Programmer</u> <u>Prod. Eng. Coord. LCA.</u>	<u>11.04.25</u> <u>OS/042</u>	<u>- Scrap + Destroy</u> <u>and Repair</u> <u>2024 T3 0.050" M114968 x4</u>	<u>11-4-05</u> <u>11/04/06</u>		<u>11.04.25</u> <u>OS/042</u>	<u>11/04/05</u>

NOTE: Date & initial all entries

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Item ID: D3637-3	Accept		Setup	Start	
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Item Name: Bracket					
Start Date: 4/12/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 4/15/2011	Req'd Qty: 10.00		Customer:		

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Brake NC Brake NC	NC BRAKE Memo Form as per Dwg D3637	0.00 0.00				<u>60</u>			
			SB	11/04/27					
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>40</u>			
150 Small Fab Small Fab Small Fab	Small Fab Memo 1- drill holes as per dwg using DT8979□2- c'sink holes as per dwg□3-deburr	0.00 0.00				<u>10X</u>			
			⇒ m-l	11/04/28					

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Tuesday, April 12, 2011 10:14:39 AM



Page 3

Item ID: D3637-3

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Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sulcu/28

(AC)

170

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

10 BL 11-4-28.

180

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 φ H alou/28

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Page 4

Tuesday, April 12, 2011 10:14:39 AM

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Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 4/12/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 	Identify as per dwg & Stock Location: <i>dy</i>	0.00							
Packaging	Memo	0.00							<i>4/12/25 (10)</i>
Packaging									
200 	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							<i>4/12/29 JJ</i>
Quality Control									

110-29-4
(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 10:14:45 AM

Page 1

Work Order ID: 68369



Parent Item: D3637-3



Parent Item Name: Bracket

Start Date: 4/12/2011

Required Date: 4/15/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-07-20 JLM Verified By:EC
IPP Rev:B change to REV.B as per dwg 08-02-11 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.050

Purchased

No

100

sf

26.0000

0.134

1.410526



2024-T3 .050 sheet

B11-4-21

Location

Loc Qty

Loc Code

MAT22

26

114968

26

114968

(10)

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Dart Aerospace Ltd

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

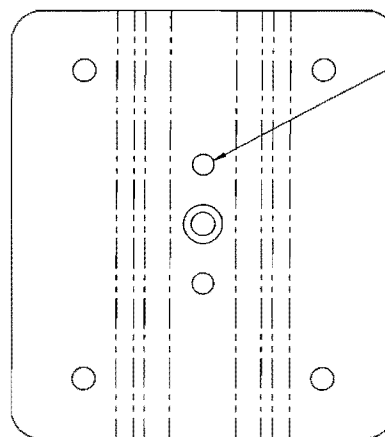
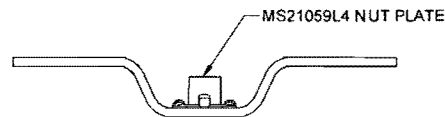
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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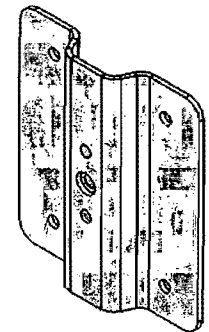
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68369

11-04-12



MS20426AD3-3 RIVET
(2 PLACES)

D3637-1 BRACKET



**D3637-041 BRACKET ASSEMBLY
(WAS GENEVA P/N G10602-1)**

D3637-041 PARTS:

QTY	P/N	DESCRIPTION
X	D3637-041	BRACKET ASSEMBLY
1	D3637-1	BRACKET
1	MS21059L4	NUTPLATE
2	MS20426AD3-3	RIVET

D3637-041 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: N/A
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3637-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.27 lbs

B	FOR D3637-1, 1 15 WAS 1.30 & "REF" REMOVED FROM ANGLE	LE	07.12.16
A	NEW ISSUE; REPLACES G10608, G10602 & G10609	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS		
DRAWN	LE		
CHECKED	EF		
MFG APPR.	EP		
APPROVED	MP		
DE APPR.	TH		
DATE	07.12.18		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3637** REV. B
TITLE **BRACKET** SCALE 1:1
SHEET 1 OF 3

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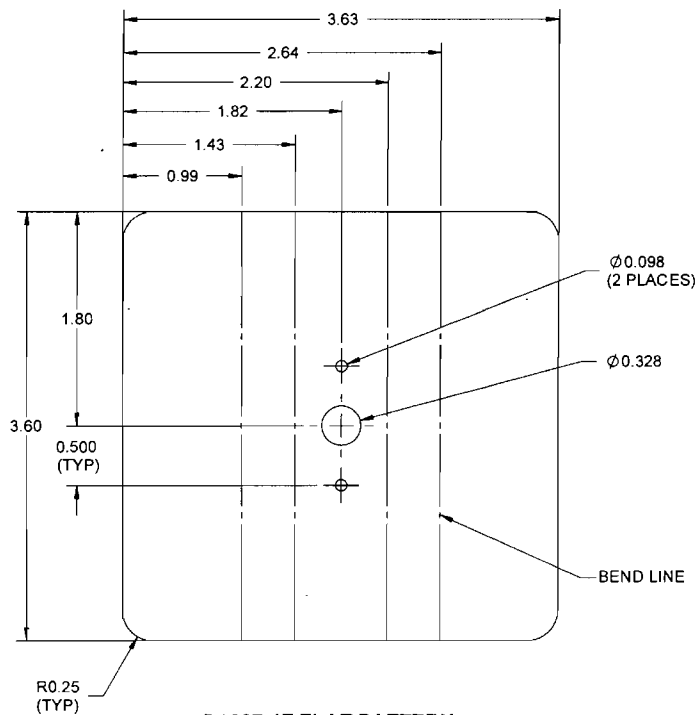
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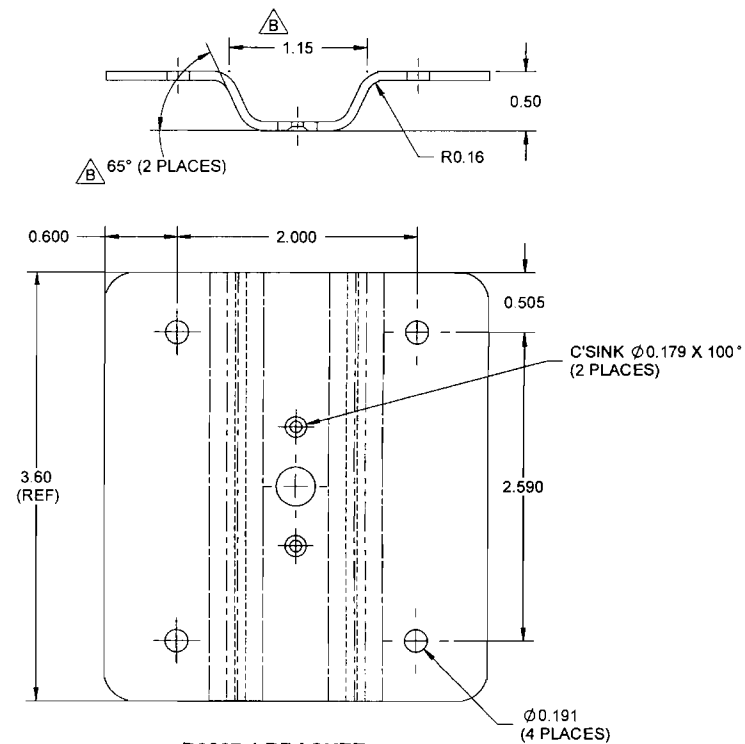
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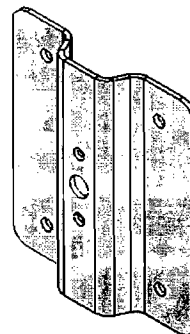
NOTE: Date & initial all entries



D3637-1F FLAT PATTERN



D3637-1 BRACKET
(WAS GENEVA P/N G10608-1)



D3637-1 NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 14 GAUGE PER MIL-S-5059 (REF DART SPEC M304S14GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lbs

DESIGN	TS	DART AEROSPACE LTD	
DRAWN	LE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LE	DRAWING NO.	REV. B
MFG. APPR.	LE	D3637	SHEET 2 OF 3
APPROVED	LE	TITLE	SCALE
DE APPR.	LE	BRACKET	1:1
DATE	07.12.18	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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RELEASED
06-22-09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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